

Date: Monday, 06/10/2008 1:21:12 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: PLUG
<b>Job Number</b>	: 42478		
<b>Estimate Number</b>	: 12338		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D3492045
<b>This Issue</b>	: 06/10/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3492 REV C
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 42184	<b>Drawing Revision</b>	: C
<b>Written By</b>	:	<b>Material</b>	:
<b>Checked &amp; Approved By</b>	: <u>JLD 08.10.06</u>	<b>Due Date</b>	: 24/10/2008
<b>Comment</b>	: Est Rev: A 06.03.21 New Issue JLM Est Rev: B 06-08-28 As per Rev B JLM Est Rev: C 07-12-06 as per rev c DD verified by: EC		

100  
 40 Um: Each

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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**Comment:** Qty.: 0.0656 f(s)/Unit Total: 2.6250 f(s)  
 6061-T6 Round Bar .500"  
 (M6061T6R500)  
 Batch: M109396

SA 08/10/15

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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**Comment:** HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA634 & Dwg D3492  
 Dwg Rev: C  
 Folio Rev: B

SA 08/10/15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/10/15

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

SA 08/10/15 (100)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

SA 08-10-15 (200)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 06/10/2008 1:21:12 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 42478

Part Number: D3492045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 109152



100X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Flat End Only)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:45  
320°F  
4:15

M-L 08/10/15

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



100

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 08/10/15

8.0

NAS1611005

O-RING



100X

Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Qty Part Number Description

1 NAS1611-005 O-RING

(or MS28775-005)

Batch  
M 102170  
M 105888

62X

38X

M-L 08/10/16

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



100X

Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube

A/R 55-O'Ring Lube Batch:

M 101223

M-L 08/10/16

10.0

QC5

INSPECT WORK TO CURRENT STEP



100

Comment: INSPECT WORK TO CURRENT STEP

M 08 10 16

11.0

PACKAGING 1

PACKAGING RESOURCE #1



100X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F P-B

M-L 08/10/16

12.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

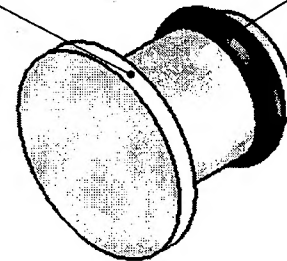
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D3492-XX PLUG  
(SEE TABLE)

NAS1611 PLUG  
(SEE TABLE)



### D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING



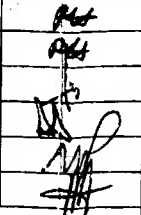
#### NOTES:

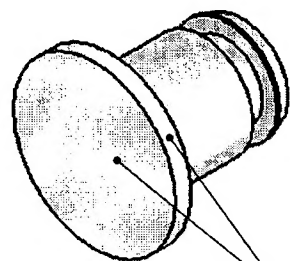
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

# 06.10.05  
UNDER REVIEW  
01.04.11  
DIM 41 ON D3492-13  
REST. OK (MAKE SMALLER)

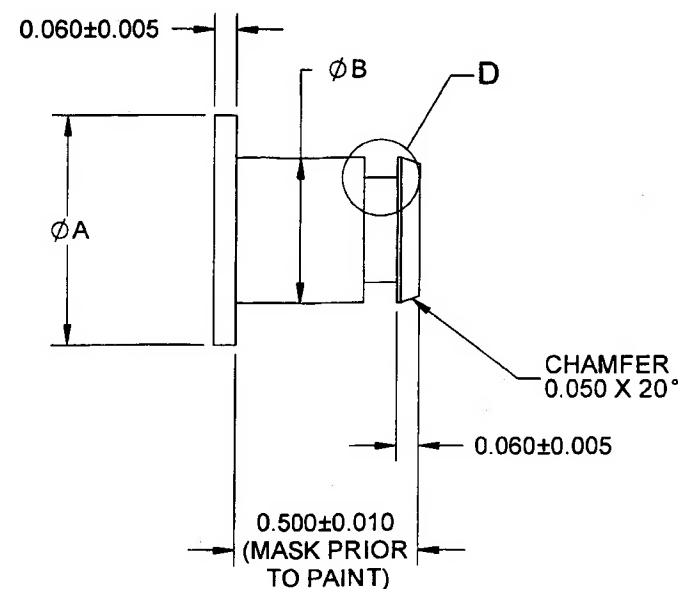
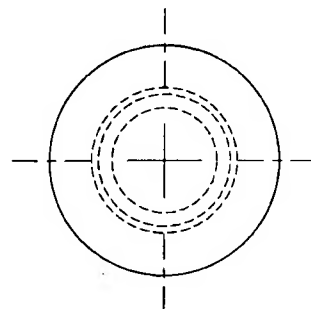
SHOP COPY  
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42418

RELEASED  
07.10.05

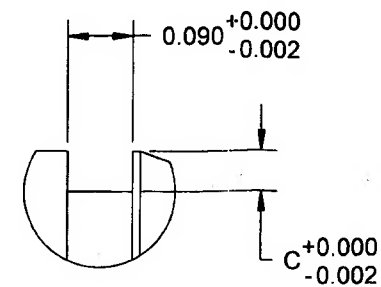
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05	DRAWING NO. <b>D3492</b>	REV. C SHEET 1 OF 2
		TITLE <b>PLUG</b>	SCALE 2:1
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POWDER COAT THESE  
FACES ONLY PER NOTE 2



**D3492-XX PLUG**



**DETAIL D**

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42478

06.10.06  
**UNDER REVIEW**  
01.04.11  
DIM ØB IN D3492-13  
REF. CK (MAKE SMALLER)

**RELEASED**  
07.11.16

DESIGN	PK	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN	PK	
CHECKED	PK	DRAWING NO. <b>D3492</b> REV. C
MFG. APPR.	PK	SHEET 2 OF 2
APPROVED	PK	TITLE <b>PLUG</b> SCALE 4:1
DE APPR.	PK	
DATE	07.10.05	

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